

Date: Friday, 25/07/2008 4:20:47 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 40760		Part Number	: D21961		
Estimate Number	: 13512		Drawing Number	: D2196 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 25/07/2008 S.O. No. :		Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 20/08/2008 Qty: 2 Um: Each		
Previous Run	:					
Written By	:					
Checked & Approved By	<u>Jul 08 7.25</u>					
Comment	: Est Rev:A 08-07-24 new issue ec verified by:dd					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 Sheet .063	
		Comment: Qty.: 0.2216 sf(s)/Unit Total : 0.4431 sf(s) 304 SS Sheet 0.063" thick batch: <u>108724</u> <u>FB 8-8-21</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2196 Dwg Rev: <u>C</u> <u>FB 8-8-21</u> Prog Rev: <u>C</u>	
		2-Deburr if necessary <u>FB 8-8-21</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>FB 8-8-21</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		Bend as per dwg D2196	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 25/07/2008 4:20:48 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET
Job Number: 40760		Part Number: D21961
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5 	INSPECT WORK TO CURRENT STEP  S 08/08/05 (+3)
7.0	PACKAGING 1 	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify with Dart part # using a fine point permanent marker and Stock Location: 18 8/8/25 3X
8.0	QC21 	FINAL INSPECTION/W/O RELEASE  Comment: FINAL INSPECTION/W/O RELEASE 08/08/26
Job Completion 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

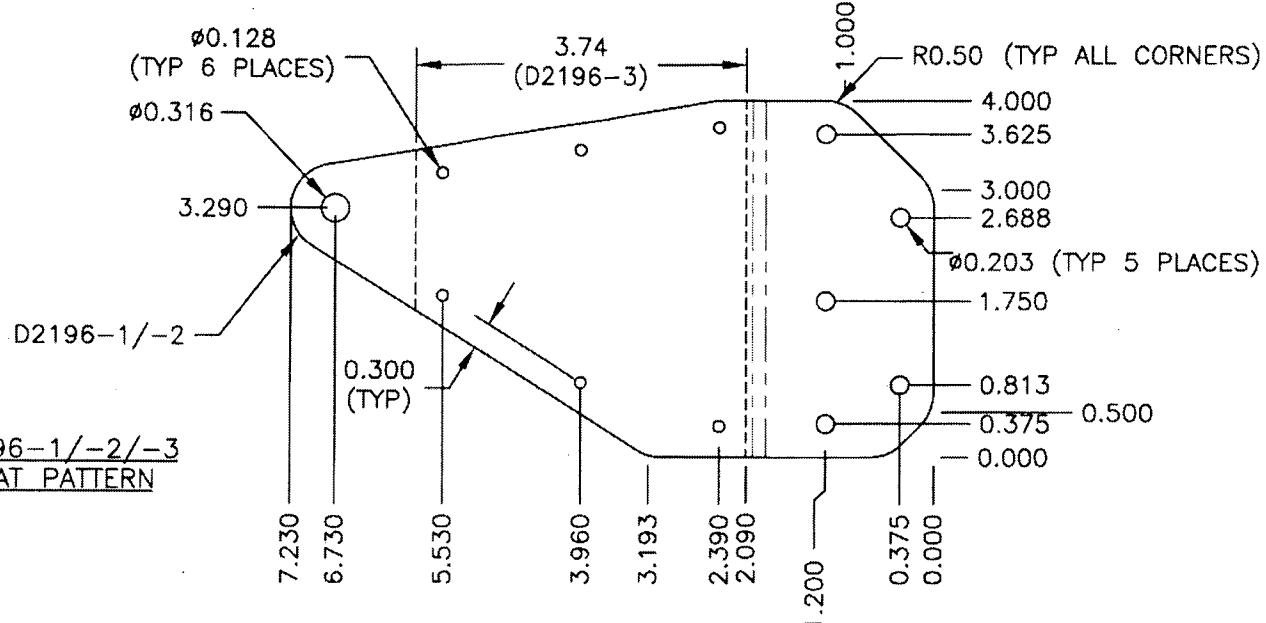
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**OACOPY  
CNC

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2196	SHEET 1 OF 1
DATE		TITLE	SCALE
03.05.28		BRACKET	1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2196-3 NOW 0.5" THICK	

D2196-1/-2

- 1) MATERIAL: AISI 304/316 S.S.  
0.064" THICK (M304S16GA)

D2196-3

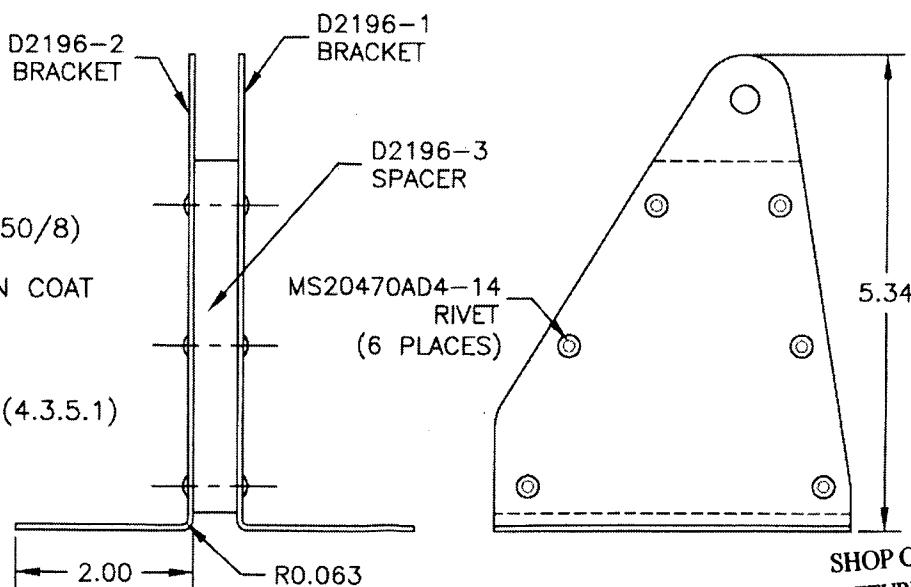
- 2) MATERIAL: 5052H32 (QQ-A-250/8)  
0.500" THICK 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1

D2196 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)  
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015

D2196 BRACKET  
(ASSEMBLY)SHOP COPY  
RETURN TO  
ENGINEERINGUNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 40100

DART AEROSPACE LTD	Work Order:	40760
Description: BRACKET	Part Number:	D2196-1
Inspection Dwg: D2196-1 Rev: C		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by: <u>B</u>	Audited by: <u>  </u>	Prototype Approval: <u>  </u> / <u>  </u>
Date: <u>8-8-21</u>	Date: <u>08/08/21</u>	Date: <u>  </u> / <u>  </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

